



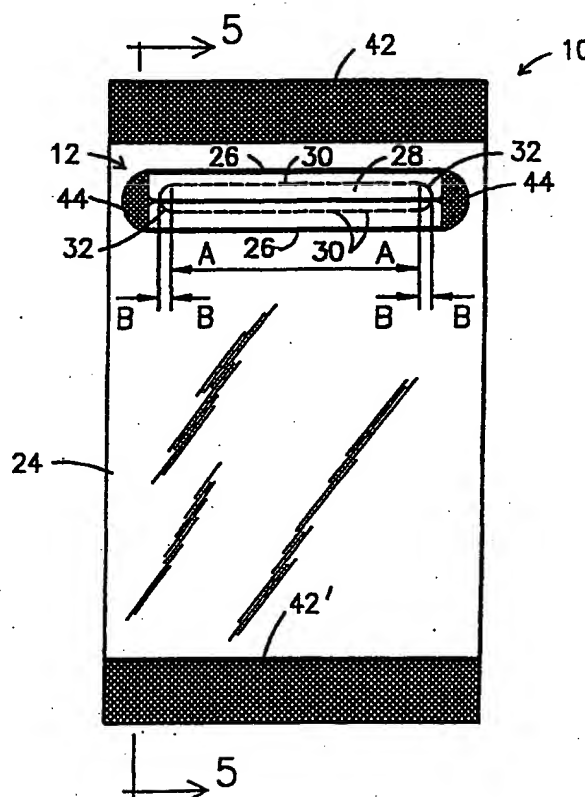
INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B65D		A2	(11) International Publication Number: WO 98/18679 (43) International Publication Date: 7 May 1998 (07.05.98)
(21) International Application Number: PCT/US97/10379 (22) International Filing Date: 20 June 1997 (20.06.97) (30) Priority Data: 08/740,438 29 October 1996 (29.10.96) US (71) Applicant: LAKELAND MICRO, INC. [US/US]; P.O. Box 6943, Lakeland, FL 33807 (US). (72) Inventors: BODOLAY, William, A.; 5621 Live Oak Road, Lakeland, FL 33813 (US). BODOLAY, Michael, J.; 5621 Live Oak Road, Lakeland, FL 33813 (US). (74) Agent: PETTIS, David, W., Jr.; P.O. Box 375, Tampa, FL 33601-0375 (US).		(81) Designated States: AU, BR, CA, JP, MX, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>Without international search report and to be republished upon receipt of that report.</i>	

(54) Title: TAMPER-EVIDENT CONTAINER WITH RECLOSABLE FASTENER AND METHOD FOR MAKING

(57) Abstract

An improved, tamper-evident container having a reclosable zipper-type fastener useful for providing access to the interior of the container is disclosed. The reclosable fastener is characterized by a pair of mating sealing strips wherein each one of the pair is attached to a common surface of the container. The container is further characterized by the provision of a security seal to provide a tamper-evident closure for the container until it is initially opened.



FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece			TR	Turkey
BG	Bulgaria	HU	Hungary	ML	Mali	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MN	Mongolia	UA	Ukraine
BR	Brazil	IL	Israel	MR	Mauritania	UG	Uganda
BY	Belarus	IS	Iceland	MW	Malawi	US	United States of America
CA	Canada	IT	Italy	MX	Mexico	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NE	Niger	VN	Viet Nam
CG	Congo	KE	Kenya	NL	Netherlands	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NO	Norway	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	NZ	New Zealand		
CM	Cameroon	KR	Republic of Korea	PL	Poland		
CN	China	KZ	Kazakhstan	PT	Portugal		
CU	Cuba	LC	Saint Lucia	RO	Romania		
CZ	Czech Republic	LI	Liechtenstein	RU	Russian Federation		
DE	Germany	LK	Sri Lanka	SD	Sudan		
DK	Denmark	LR	Liberia	SE	Sweden		
EE	Estonia			SG	Singapore		

ENTITLED: TAMPER-EVIDENT CONTAINER WITH RECLOSABLE
FASTENER AND METHOD FOR MAKING

BACKGROUND OF THE INVENTION

5 Field of the Invention.

The present invention relates to an improved reclosable, tamper-evident container formed, at least in part, from a flexible material. Access to the interior of such a container is provided by a security seal formed through the flexible material, and the reclosable fastener of this invention is attached to the container
10 in sealing relation to that seal. The improved fastener of this invention is particularly characterized by its structure comprising a pair of mating, reclosable sealing strips, both of which are attached to a common surface of the container's flexible material. Preferably, the reclosable fastener of this invention is disposed on the inside surface of the container.

Description of the Prior Art.

Reclosable containers utilizing zipper-type fasteners are well known in the packaging industry and are used for holding, displaying and dispensing a wide variety of products ranging from hardware items to food products intended for human consumption. The construction of virtually all such prior art fasteners comprises one or more female parts which releasably receive one or more corresponding male parts. In order to provide access to the interior of the container, those portions of the fastener bearing the respective female and male parts must typically be attached to opposing sides of the container such that the female and male parts will be in registry with each other. A typical such construction is disclosed in U. S. Patent No. 4,909,017 to McMahon and Spanier.

Obviously, then, according to the present state of the packaging arts, great care and precision are required in the placement and attachment of reclosable fasteners to their related containers. Notwithstanding the existence of a great variety of such fasteners and reclosable containers utilizing such fasteners, it is clear that there remains a great need in the packaging arts for a reclosable, zipper-type fastener, both parts of which can be attached to a single common surface of the material forming a wall of the container before the container is even partially formed. Such a fastener would significantly simplify the manufacturing process for reclosable containers by not interfering with the operation of standard forming and filling machines.

SUMMARY OF THE INVENTION

The present invention relates to an improved tamper-evident container formed from a flexible material and having a reclosable fastener. In a preferred embodiment, the fastener of this invention comprises a pair of mating, reclosable sealing strips, each comprising a strip base segment which is attachable to a common surface of the material forming a wall of a reclosable container. Each
5 of the sealing strips further comprise a second segment integral with its corresponding base segment and free from the container wall surface. One of the strips comprises a male fastener part, and the other of the strips comprises a female fastener part in receiving relation to the male part. Tamper-evident
10 access to the interior of the container is provided by a removable portion of the flexible material to form an aperture for access to the reclosable fastener.

According to a first embodiment of the reclosable fastener, the male fastener part is at the juncture of one of the base segments and its corresponding second segment, and the female fastener part is formed on the second segment
15 of the other sealing strip. Both base segments are attached to a common interior surface of the flexible material, and both second segments are free from the common surface.

According to a second embodiment, the female fastener part is formed on one of the sealing strip second segments, and that second segment is attached to
20 a second surface of the flexible material opposite the common surface.

Also disclosed and claimed hereinafter is a method for attaching the reclosable zipper-type fastener to the flexible material from which the container is made so as to provide a tamper-evident reclosable seal.

The invention accordingly comprises the features of construction, combination of elements, and arrangement of parts which will be exemplified in
5 the constructions hereinafter set forth, and the scope of the invention will be indicated in the claims.

BRIEF DESCRIPTION OF THE DRAWINGS

For a fuller understanding of the nature and objects of the invention, reference should be had to the following detailed description taken in connection with the accompanying drawings, in which:

FIGURE 1 is a side elevation showing a segment of a first embodiment
5 of the container of this invention with the fastener attached to the inside of a segment of the flexible material at least partially forming a reclosable container.

FIGURE 2 is a side elevation similar to that of Fig. 1 showing the segment of the reclosable container with the tamper-evident portion removed and the fastener opened.

10 **FIGURE 3** is a view similar to that of Fig. 1 showing a second embodiment of the container.

FIGURE 4 is a side elevation similar to that of Fig. 3 showing the segment of the reclosable container with the tamper-evident portion removed and the fastener opened.

15 **FIGURE 5** is a sectional view taken along line 5-5 of Fig. 6 showing attachment of the reclosable fastener to a common interior surface of a reclosable container.

FIGURE 6 is a plan view of the reclosable container shown in Fig. 5.

Similar reference characters refer to similar parts throughout the several
20 views of the drawings.

DETAILED DESCRIPTION

A first embodiment of the improved tamper-evident container formed from a flexible material and having a reclosable fastener is generally indicated as 10 in the views of Figs. 1, 2, 5 and 6. The reclosable fastener is generally indicated as 12.

5 Referring to the view of Fig. 1, it can be seen that fastener 12 comprises a pair of mating, reclosable sealing strips, generally indicated as 14 and 16, respectively. Each of the sealing strips 14 and 16 comprise a base segment 18 and 20, respectively. Base segment 18 is attached to interior surface 22 of flexible material 24, and base segment 20 is similarly attached to the common
10 interior surface 22. As shown in Fig. 1, attachment of the fastener 12 to common interior surface 22 is indicated by perimeter seal 26.

Also shown in the view of Fig. 1 is a removable portion 28 of flexible material 24 by which access to the interior of container 10 may be obtained once portion 28 is removed to form an aperture providing access to strips 14 and 16
15 whereby they may be separated from each other. This is clearly illustrated in the "opened" view of Fig. 2. Referring to the view of Fig. 6, it can be seen that removable portion 28 is defined by a plurality of cuts formed through flexible material 24. In the preferred embodiment, these cuts comprise a plurality of perforations 30 and at least one slit 32, though a pair of opposed slits 32 are
20 illustrated in the view of Fig. 6. Slit 32 provides a free segment of flexible material 24 whereby portion 28 may be removed to provide access to fastener 12.

The perforations 30 are preferably formed within the area defined by line A-A, and the slit, or slits, 32 are preferably formed within the area between arrows B.

Returning to the view of Fig. 1, sealing strip 14 further comprises a second segment 34 integrally formed therewith, but not attached to common interior surface 22. Sealing strip 16 also comprises a second segment 36 integral with its base segment 20, but not attached to common interior surface 22. A female fastener part 38 is formed on second segment 34, and a corresponding male fastener part 40 is formed on sealing strip 16 at the juncture of base segment 20 with second segment 36.

As further shown in the view of Fig. 1, container 10 further includes another segment of flexible material 24' forming another wall thereof, and a seam 42 is provided by the joining of flexible material 24 to a corresponding segment of flexible material 24'. Referring to the views of Figs. 5 and 6, a similar seam 42' is formed at the bottom of container 10.

Referring to the view of Fig. 6, and remembering that a principal end use for the container 10 is to hold food products intended for human consumption, the formation of an hermetic seal is a particular advantage of this invention. As shown in Fig. 6, the perimeter seal 26 extends around the perimeter of fastener 12. However, a broadened segment 44 can be seen at each end of perimeter seal 26. Broadened segment 44 is frequently referred to in the packaging industry as a "splotch" seal. Such a splotch seal involves the application of heat and pressure to the distal ends of sealing strips 14 and 16 so as to form a flattened, broadened segment 44. Then, when the fastener 12 is attached to common

interior surface 22 of flexible material 24 by the perimeter seal 26, an hermetic seal is formed in completely surrounding relation to the removable portion 28.

Referring now to the views of Figs. 3 and 4, a second embodiment of the tamper-evident container is generally indicated as 10'. Inasmuch as the structural elements of container 10' are essentially identical to those of first embodiment 10, identical reference numerals have been used for their identification. As
5 clearly shown in the views of Figs. 3 and 4, second embodiment 10' further comprises a tack seal 46 to bond second segment 34 to inside surface 48 of flexible material 24' forming the opposite side of container 10'. Such a construction virtually eliminates any probability of material contained within
10 container 10' becoming wedged or caught in the gap otherwise present between second segment 34 and flexible material 24'.

From the above description of the structure of first and second embodiments of the container 10 and 10', respectively, attention is now invited to the following description of the method for attaching fastener 12 to a flexible
15 material 24 for providing a tamper-evident reclosable opening therethrough. First, a segment of flexible material 24 is selected for forming a container 10. A plurality of cuts comprising perforations 30 and at least one slit 32 are made to define a removable portion 28. Next, a reclosable zipper-type fastener 12 is selected and cut to a predetermined length sufficient to overlie the removable
20 portion 28. Opposed distal ends of fastener 12 are then "spotched" and the spotched length of fastener is disposed in adjacent, overlying relation to removable portion 28. The perimeter seal 26 is formed by the application of pressure and heat. If desired, tack seal 46 would be made in a subsequent step.

From that point on, the container would be formed and filled using standard form and fill apparatus and methods. No further manipulation of fastener 12 and its related removable portion 28 is required.

It will thus be seen that the objects set forth above, among those made apparent from the preceding description, are efficiently attained, and, since
5 certain changes may be made in the above construction without departing from the scope of the invention, it is intended that all matter contained in the above description or shown in the accompanying drawings shall be interpreted as illustrative and not in a limiting sense.

It is also to be understood that the following claims are intended to cover
10 all of the generic and specific features of the invention herein described, and all statements of the scope of the invention which, as a matter of language, might be said to fall therebetween.

Now that the invention has been described,

What Is Claimed Is:

1. A method for attaching a reclosable zipper fastener to a flexible material from which a container is made so as to provide a tamper-evident reclosable seal, said method comprising the steps of:

- (a) selecting a segment of flexible material to be used for
5 forming a container;
- (b) forming a plurality of cuts through said segment to define a removable portion;
- (c) selecting a reclosable zipper fastener comprising a pair of mating, reclosable sealing strips;
- 10 (d) cutting said fastener to a predetermined length sufficient to overly said removable portion;
- (e) forming a splotch seal at opposed distal ends of said strips at each end of said length by the application of heat and pressure to yield a flattened, broadened segment at each of said opposed distal ends;
- 15 (f) placing said splotch sealed fastener adjacent said flexible material in overlying relation to said cuts; and
- (g) attaching said splotch sealed fastener to said flexible material by forming a perimeter seal around said removable portion between said fastener and said flexible material such that said perimeter seal is continuous
20 around the perimeter of said sealed fastener.

1/5

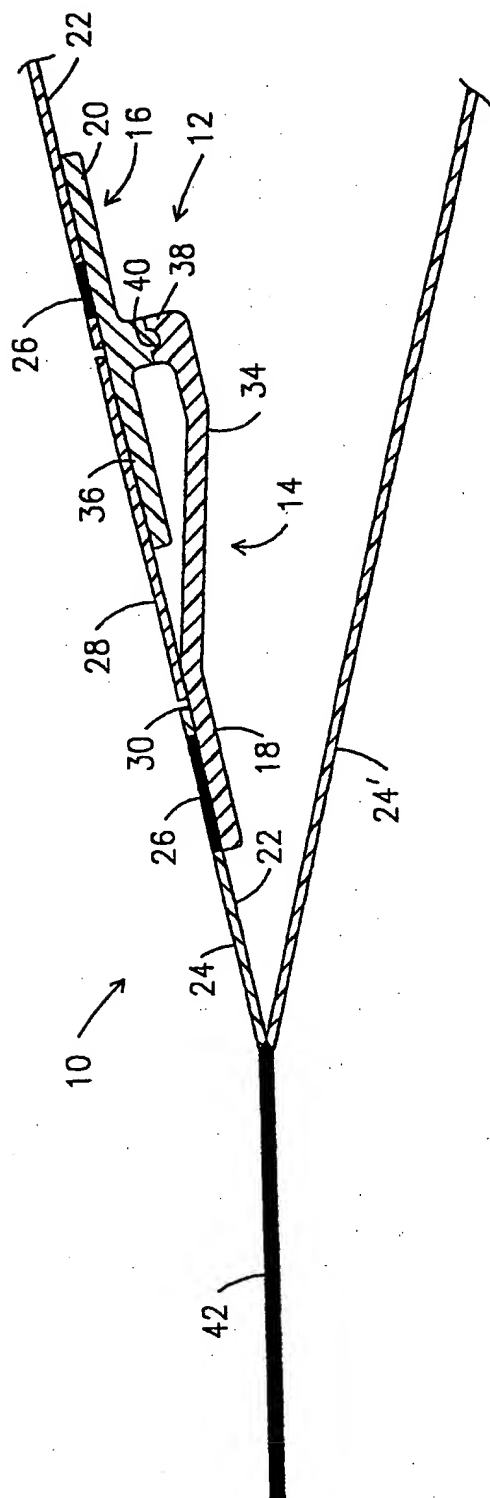


Fig. 1

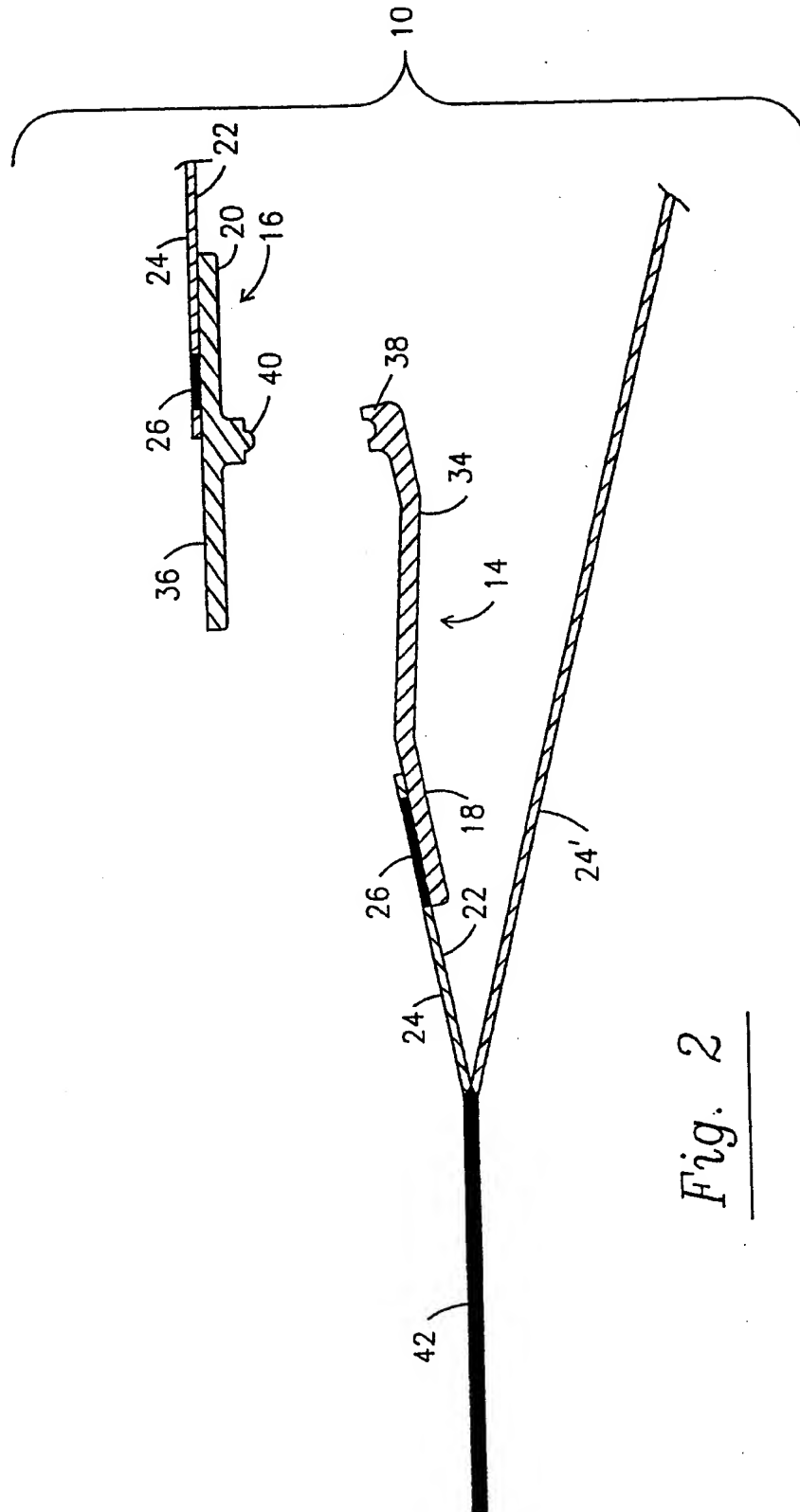


Fig. 2

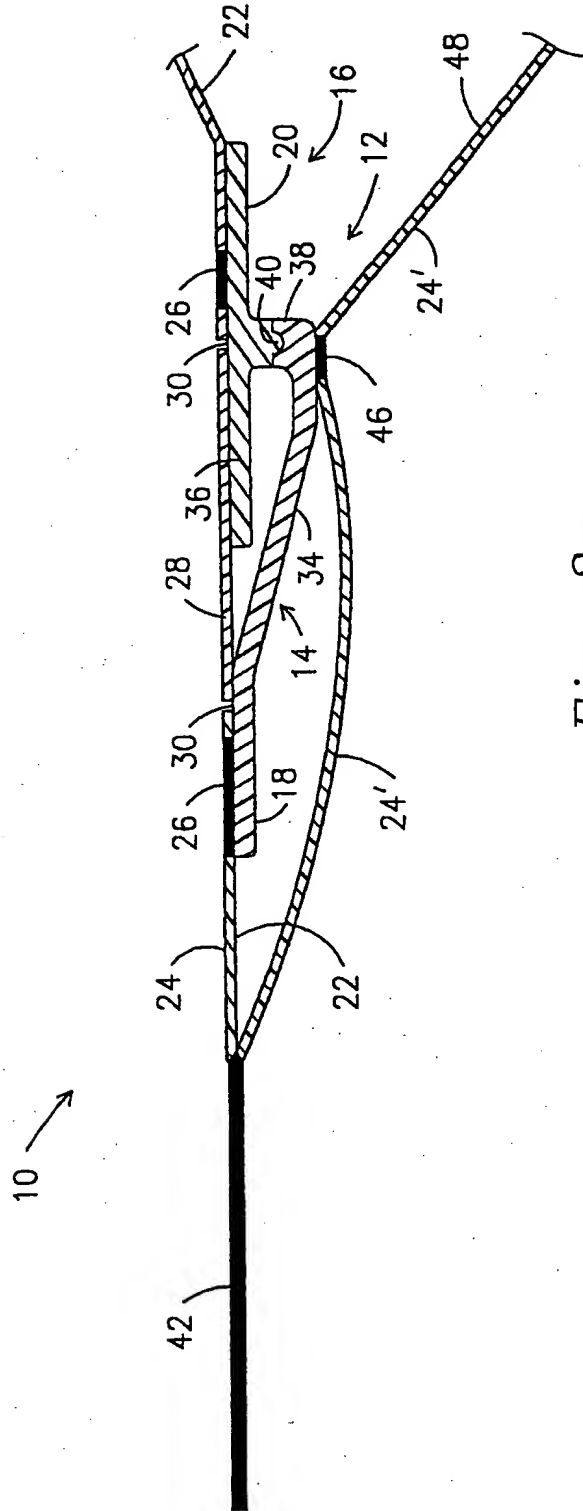
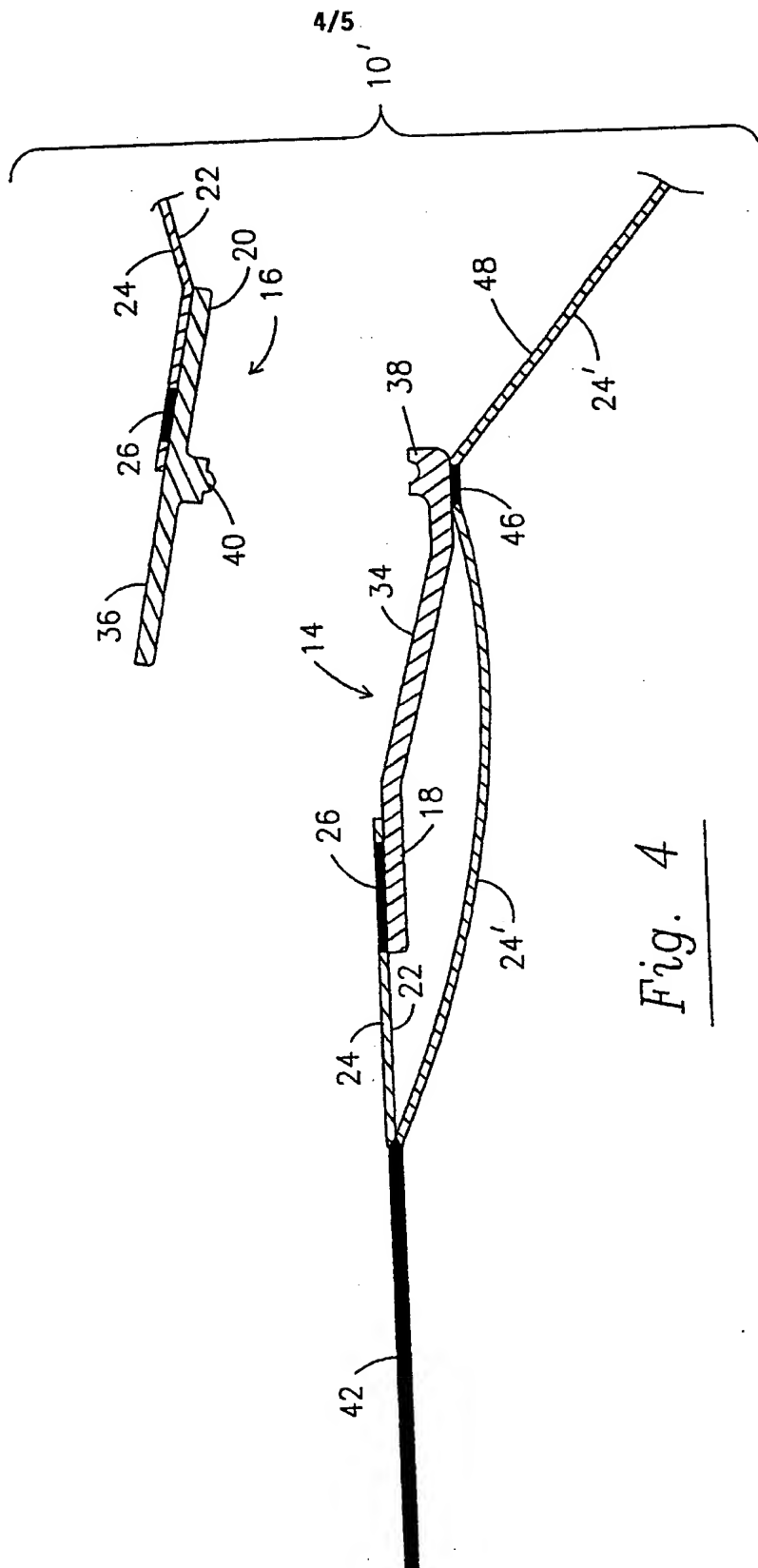


Fig. 3



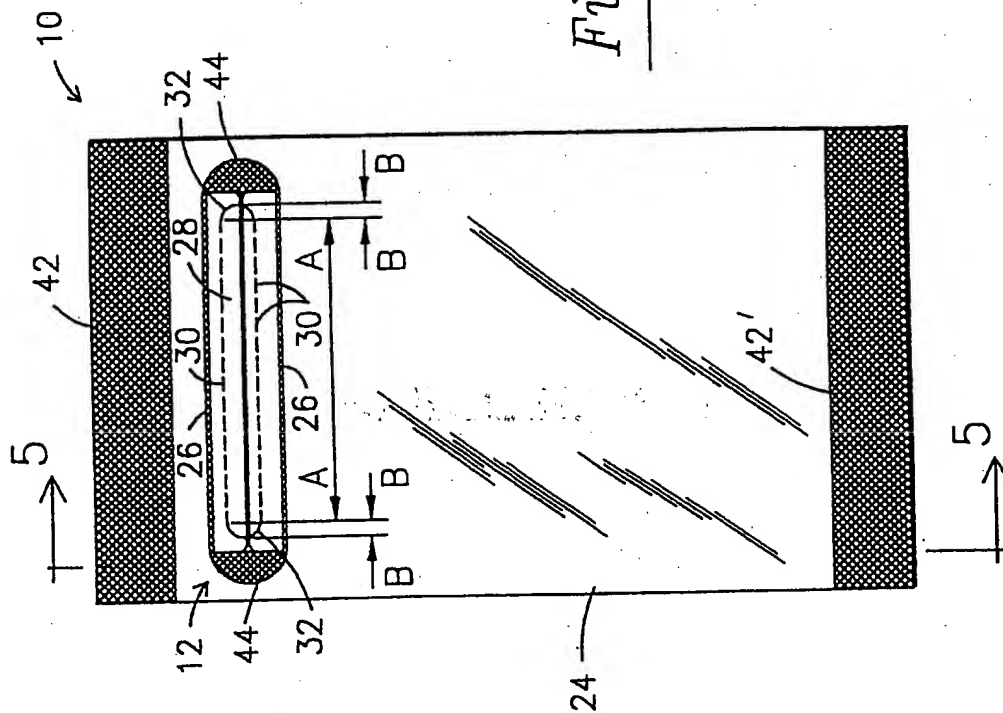


Fig. 6

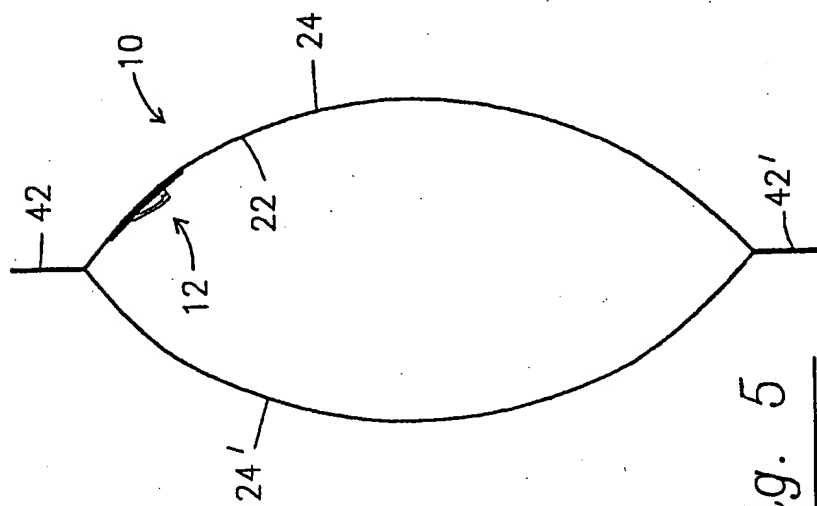


Fig. 5

THIS PAGE BLANK (USPTO)